

DART SERVICE INSTRUCTION

TO AMEND IIN-D412-809 REV. A,
AND ICA-D412-809 REV. 0
REF. TCCA SSTC: C-LSH11-100/D

1.0 PURPOSE

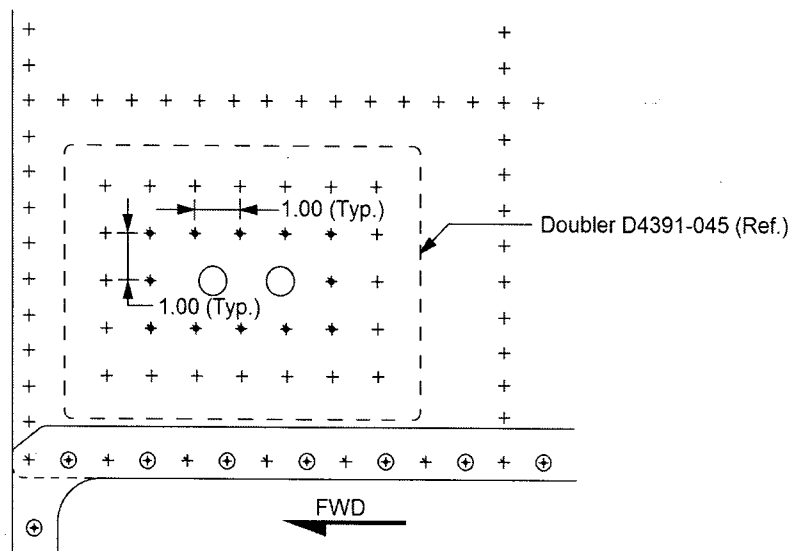
The purpose of this DSI is to provide additional installation instructions for the Bell 412EP Avionics Modification outlined in IIN-D412-809 Rev. A to obtain positive margins per SUB-D412-809-1 Rev. A.

2.0 MODIFICATION TO #2 GPS / VHF COMM ANTENNA INSTALLATION

(Ref. IIN-D412-809 Rev. A Section 2.1.6)

2.1 Remove & retain four MS24693S278 Screws, four NAS1149D0332J Washers, four MS21042L3 Nuts and one Comant CI 2580-200 Antenna located on the cabin roof at STA40 and BL14.

2.2 Install twelve MS20426AD3 Rivets as shown:



Fastener Key:

- ✦ MS20426AD3 Rivets (NEW)
- ✦ MS20470AD4 Rivets (Existing)

2.3 Re-install the Comant CI 2580-200 Antenna as indicated in IIN-D412-809 Rev. A Section 2.1.6.c through Section 2.1.6.g.

A	NEW ISSUE	DW	11.06.01
REV.	DESCRIPTION	BY	DATE
DESIGN	DW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DW		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9575	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	809 STRUCT. MODIFICATION	NTS
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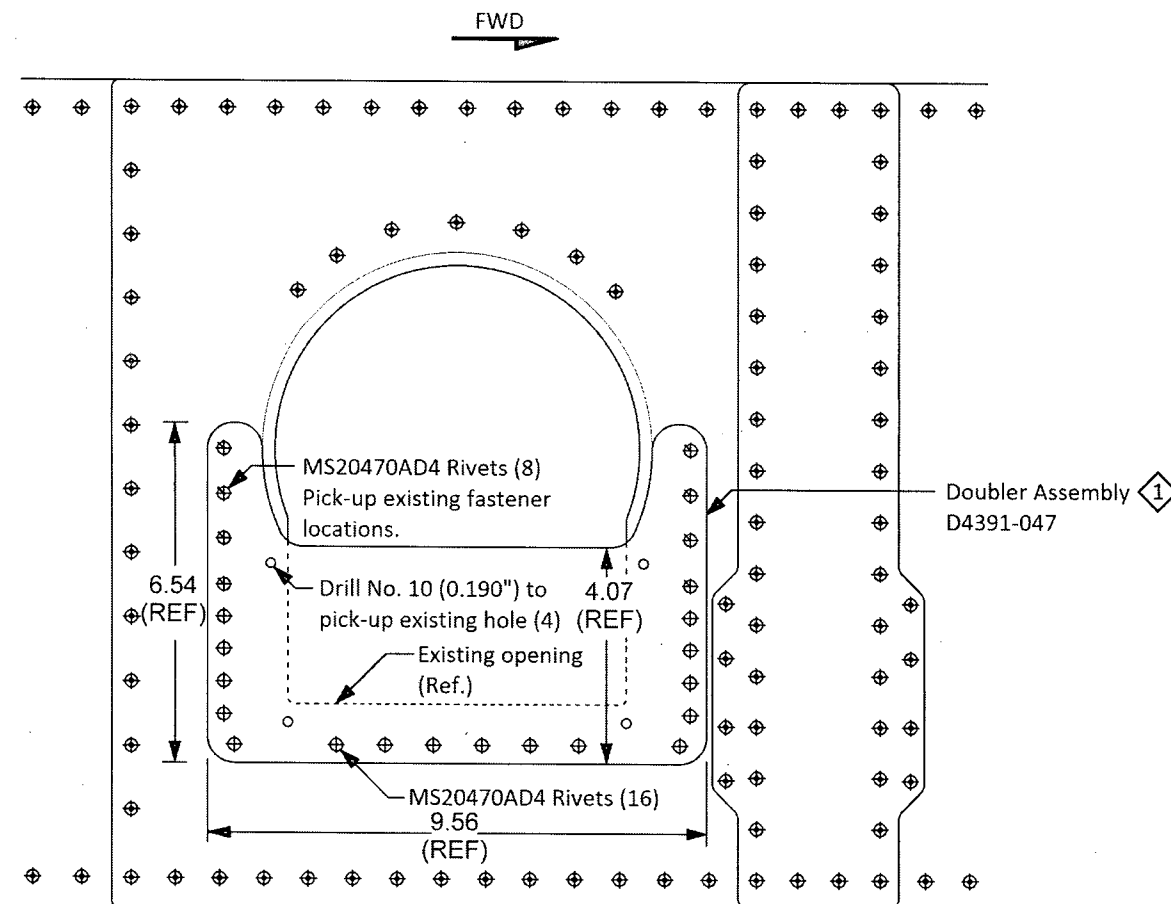
3.0 MODIFICATION TO R/H CREW BECKER ACU6100 INSTALLATION

(Ref. IIN-D412-809 Rev. A Section 2.2.4)

3.1 Remove & retain R/H Crew ACU6100 located in the cabin roof on the right hand side of the cabin in the bay ahead of STA129.

3.2 Remove & retain four AN525-10-6 Screws and Bracket Assy D4391-043 (including attached DZUS fastener rails).

3.3 Fabricate & install Doubler Assembly D4391-047 as shown:



Notes:

1. Fabricate D4391-047 from 0.040" 2024-T3 Sheet (QQ-A-250/5).
2. Maintain 0.32" minimum edge distance, minimum 0.50" pitch, maximum 1.00" pitch for all MS20470AD4 rivets installed.

3.4 Re-install Bracket Assy D4391-043 (including attached DZUS fastener rails) in accordance with IIN-D412-809 Rev. A Section 2.2.4.b. Substitute AN525-10-7 screws for AN525-10-6 screws if necessary to maintain 2 threads minimum past the anchor nuts included on D4391-043.

3.5 Re-install R/H Crew ACU6100 in accordance with IIN-D412-809 Rev. A Section 2.2.4.d.

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